

540

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24205
<b>Description: End Plate</b>	<b>Part Number:</b>	D3067-1
<b>Drawing: D3067 Rev. A</b>	<b>Qty:</b>	80
Page 1 of 1		

RF 02/10/17

Stack of 8

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	AR	05/09/07	80
2	MV	Cut blanks 2.750" x 3.030" +/- 0.005 <b>Grain along 2.750"</b> Material: 5052-H32 (QQ-A-250/8) (M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063) Batch: 116454	RM	05/09/22	80
3	MV	Machine per folio FA183 and Dwg D3067	RM	05/09/23	80
4	QC2	Inspect parts as they come off the CNC machine	RM	05/09/23	80
5	QC7	Second inspection	UP	05.09.22	80
6	MV	Deburr			
7	GB	Bend as per Dwg D3067	SP	05/10/05	80
8	QC5	Inspect work to Step 7		05-10-05	80
9	WA	Identify and stock		05-10-05	80
10	AC	Cost / Part 1.37	SUC	05-10-06	80
11	DC	Close W/O 1.06 Inspect level 21	LD	05/10/06	80

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	EC	
B	02.01.03	Now machined on HAAS	SM	
C	02.10.04	Re-format	KJ RF	
C1	03.01.21	Remove step 6 (Deburr)	RF	

RELEASED  
02/10/15 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LS Date: 05/10/06

NOTE: Date & initial all entries

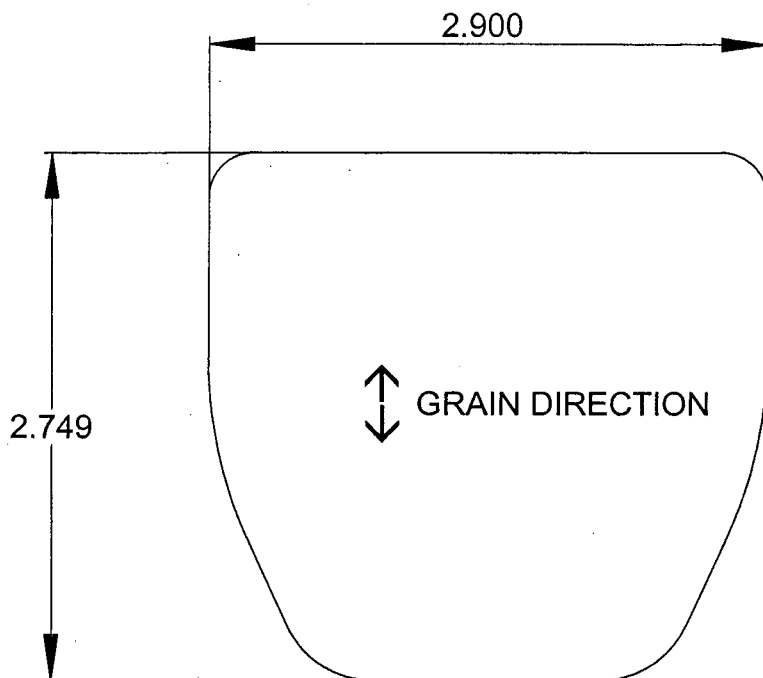
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



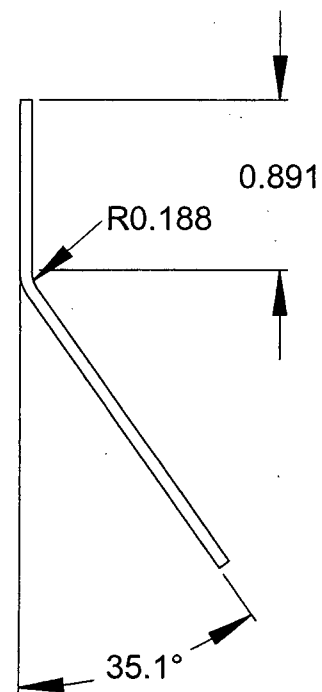


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED  
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063) OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063) ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Sep 02, 2005  
09:01 am

Work Order No : 0024205  
Project Name : D3067-1  
Project For : WK540  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3067-1  
Description : End Plate  
Manufactured : Yes  
Amount Req'd : 80  
Amount Done : 0  
Start Date : 09-01-05  
Est Finish Date : 10-06-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00